



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D5469-1**  
**Job Sheet 187835**



Part No: D5469-1

Job Qty: 4 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation     | 4 Ea  | 1/11/19    | 1/11/19  | 0.00      | 0.00    | Start Up Machining-4  |           | SBC 18/12/19 |
| 100   | CNC Vertical Machining | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 7.93    | HAAS1-1               |           | VH8 18/12/21 |
| 120   | QC                     | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.00    | QC2 Machining-4       |           |              |
| 130   | QC                     | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.00    | QC8 Machining-4       |           |              |
| 140   | HandFinish             | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.56    | HandFinish1           |           |              |
| 150   | SprayPaint             | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.10    | Spray Paint           |           |              |
| 160   | QC                     | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.00    | QC14                  |           |              |
| 170   | Packaging              | 4 pcs | 1/11/19    | 1/11/19  | 0.00      | 0.00    | Packaging3-2          | ST399     |              |
| 180   | QC21-SA                | 4 Ea  | 1/11/19    | 1/11/19  | 0.00      | 0.00    | QC21                  |           | JAN 23 2019  |

Part Op 100 - Program Batch No. 5138990 Double check by: JA 1-Machine Step No 1 per Folio FB548 and inspect per  
Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine  
Step No 3 per Folio FB548 and insp  
150 - \*\*\*MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8\*\*\* 1-PRIME AS PER DWG AND QSI005  
4.2.1.3.3 PRIMER BATCH: \_\_\_\_\_ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT  
BATCH: \_\_\_\_\_

163: Outsource: Atelier - 00432329 - 19-01-10  
165: Receiving 4X JAN 17 2019  
167: QC 6

| Part / Item | Component Name | Quantity    | Operation             | Container |
|-------------|----------------|-------------|-----------------------|-----------|
| D6101-005   | Saddle Billet  | 4 Ea (1 ea) | 90-Start up Operation | 5136639   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6101-005      | 4        | 16        | 0         |

### Part Specifications

Specifications could not be found.



Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

|                              |  |                                                       |                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                            |
|------------------------------|--|-------------------------------------------------------|----------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------|
| Job: _____<br>Part No. _____ |  | DISPOSITION                                           |                                                          | <div>Part: D5469-1<br/>Job No: 187835<br/>Serial No/ Batch: S138990<br/>Revision: A<br/>Inspector:<br/>Exp Date:<br/>Instructions: Various STC's</div> <div>Container No: S138990</div> <div><div>Part Aerospace Ltd.<br/>1270 Aberdeen Street<br/>Hewesbury, ON K6d 1k7<br/>CANADA<br/>TEL: 1 613 632-5200<br/>Email: sales@partaero.com<br/>www.partaerospace.com</div></div> <div>Non-AW) _____<br/>ng. Coord. _____<br/>ackaging _____</div> <div>Engineering _____<br/>Water Jet _____<br/>Supplier _____<br/>Quality _____</div> <div>MRB (QSI042)</div> |                                            |
| Date: _____                  |  | Description Work _____                                |                                                          | Completed By _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                            |
|                              |  |                                                       |                                                          | Lead hand / Supervisor _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                            |
|                              |  |                                                       |                                                          | QC / QA Coordinator _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                            |
| Root Cause                   |  | FAULT CATEGORY                                        |                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                            |
| Operator _____               |  | <input type="checkbox"/> Pressure/Forced              | <input type="checkbox"/> Contamination                   | <input type="checkbox"/> Power Loss/Surge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <input type="checkbox"/> Positioned Wrong  |
| Manufacturing Process _____  |  | <input type="checkbox"/> Bending                      | <input type="checkbox"/> Misaligned/off center           | <input type="checkbox"/> Folio/Program                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <input type="checkbox"/> Outside Tolerance |
| Equip/Tooling _____          |  | <input type="checkbox"/> Crushing                     | <input type="checkbox"/> BOM/Route                       | <input type="checkbox"/> Grain Direction                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <input type="checkbox"/> Drawing           |
| Handling/Presservation _____ |  | <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damage/Defect            | <input type="checkbox"/> Weld                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <input type="checkbox"/> Finish            |
| Material _____               |  | <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist | <input type="checkbox"/> Incomplete/Unclear Instructions | <input type="checkbox"/> Wrong Stock Pulled                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> Part Lost/Missing |
| Product Improvement _____    |  | <input type="checkbox"/> Marks/Chatter                | <input type="checkbox"/> Drill Holes                     | <input type="checkbox"/> Out of Sequence                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <input type="checkbox"/> Misread           |
| Process Improvement _____    |  | <input type="checkbox"/> Mislabeled                   | <input type="checkbox"/> Fit/Function                    | <input type="checkbox"/> Off-set/Set-up                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                            |
| Human Factors _____          |  | Other/Details: _____                                  |                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                            |



|                                      |  |                             |
|--------------------------------------|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>            |  | <b>Work Order:</b> 187835   |
| <b>Description:</b> Inner AFT SADDLE |  | <b>Part Number:</b> D5469-1 |
| <b>Inspection Dwg</b> D5469 Rev A    |  | <b>Page 1 of 1</b>          |

|               |       |       |                | Recorded Actual Dimensions |        |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|--------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2      | 3     | 4     | By | Date |
| A             | 0.438 | 0.443 |                | 0.488                      | 0.438  | 0.438 | 0.438 |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750  | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500  | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.7500 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 7.995                      | 8.000  | 8.000 | 8.000 |    |      |
| F             | 0.490 | 0.510 | 0.501          | 0.500                      | 0.499  | 0.499 | 0.500 |    |      |
| G             | 0.257 | 0.262 |                | 0.257                      | 0.257  | 0.257 | 0.257 |    |      |
| H             | 0.375 | 0.380 |                | 0.375                      | 0.375  | 0.375 | 0.375 |    |      |
| I             | 0.490 | 0.510 |                | 0.500                      | 0.500  | 0.500 | 0.500 |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179  | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | 0.5675                     | 0.565  | 0.568 | 0.568 |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179  | 1.179 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370  | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500  | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124  | 4.124 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | 0.120                      | 0.125  | 0.125 | 0.125 |    |      |
| Q             | 0.115 | 0.135 |                | 0.124                      | 0.124  | 0.125 | 0.124 |    |      |
| R             | 0.240 | 0.260 |                | 0.253                      | 0.253  | 0.253 | 0.254 |    |      |
| S             | 0.115 | 0.135 |                | 0.128                      | 0.130  | 0.132 | 0.129 |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188  | 0.188 | 0.188 |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230  | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | 0.243                      | 0.243  | 0.243 | 0.243 |    |      |
| W             | 0.115 | 0.135 |                | 0.130                      | 0.134  | 0.131 | 0.133 |    |      |
| X             | 0.307 | 0.312 |                |                            |        |       |       |    |      |
| Y             | 0.760 | 0.765 |                |                            |        |       |       |    |      |
| Z             | 0.352 | 0.372 |                | 0.363                      | 0.365  | 0.365 | 0.365 |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500  | 0.500 | 0.500 |    |      |
| AB            | 0.615 | 0.635 |                | 0.623                      | 0.626  | 0.625 | 0.622 |    |      |
| AC            | 0.053 | 0.073 |                | 0.065                      | 0.065  | 0.065 | 0.065 |    |      |
| AD            | 0.240 | 0.260 |                | 0.253                      | 0.254  | 0.254 | 0.253 |    |      |
| AE            | 1.500 | 1.520 |                | 1.510                      | 1.510  | 1.510 | 1.510 |    |      |
| AF            | 0.115 | 0.135 |                | 0.125                      | 0.125  | 0.125 | 0.125 |    |      |
| AG            | 0.240 | 0.280 |                | 0.250                      | 0.250  | 0.250 | 0.250 |    |      |
| AH            | 0.240 | 0.260 |                | 0.253                      | 0.253  | 0.250 | 0.250 |    |      |
| AI            | 2.000 | 2.020 |                | 2.010                      | 2.010  | 2.010 | 2.010 |    |      |
| AJ            | 0.023 | 0.043 |                |                            |        |       |       |    |      |
| Accept/Reject |       |       |                |                            |        |       |       |    |      |

|                         |                       |
|-------------------------|-----------------------|
| Measured by: <i>VJA</i> | Audited by: <i>mf</i> |
| Date: 18/12/21          | Date: 19/01/05        |



Dart Aerospace Ltd.  
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Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO042232



**Supplier:** ATE003-VC  
Atelier Debosselage  
358 Principale  
Calumet  
QC  
J0V 1B0 Canada  
Phone: 819 242 5633

**PO No:** PO042232  
**PO Date:** 1/10/19  
**Due Date:**  
**Purchase Order Revision:**  
**Revision Date:**  
**Ship-To Contact:** Tsimiklis, ChrisoulaPhone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

### Items

| Line Item | Job    | Part    | Description                                                                                                                                                                                                                                                                             | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|--------|---------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 187832 | D5466-1 | Saddle, Fwd, In<br>: Various STC's<br>ISSUE P/O:<br><br>***MASK HOLES PRIOR TO<br>PRIME AND PAINT AS PER<br>DWG NOTE 8***<br><br>1-PRIME AS PER DWG AND<br>QSI005 4.2.1.3.3 PRIMER<br>BATCH:<br><br>2-PAINT AS PER DWG AND<br>QSI005 4.2.2.4 PAINT<br>BATCH:<br><br>C OF C IS REQUIRED  | Firmed | -       |          | 4 pcs          | 0 pcs             | 4 pcs   | \$25.00/pcs      | \$100.00       |
| 2         | 187833 | D5467-1 | Saddle, Fwd, Out<br>: Various STC's<br>ISSUE P/O:<br><br>***MASK HOLES PRIOR TO<br>PRIME AND PAINT AS PER<br>DWG NOTE 8***<br><br>1-PRIME AS PER DWG AND<br>QSI005 4.2.1.3.3 PRIMER<br>BATCH:<br><br>2-PAINT AS PER DWG AND<br>QSI005 4.2.2.4 PAINT<br>BATCH:<br><br>C OF C IS REQUIRED | Firmed | -       |          | 4 pcs          | 0 pcs             | 4 pcs   | \$25.00/pcs      | \$100.00       |





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# PURCHASE ORDER PO042232



## Items

| Line Item    | Job    | Part    | Description                                                                                                                                                                                                                                                                                               | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|--------------|--------|---------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 3            | 187834 | D5468-1 | Saddle, Aft, Out<br>: Various STC's<br>ISSUE P/O: _____<br><br>***MASK HOLES PRIOR TO<br>PRIME AND PAINT AS PER<br>DWG NOTE 8***<br><br>1-PRIME AS PER DWG AND<br>QSI005 4.2.1.3.3 PRIMER<br>BATCH: _____<br><br>2-PAINT AS PER DWG AND<br>QSI005 4.2.2.4 PAINT<br>BATCH: _____<br><br>C OF C IS REQUIRED | Firmed | -       |          | 4 pcs          | 0 pcs             | 4 pcs   | \$25.00/pcs      | \$100.00       |
| 4            | 187835 | D5469-1 | Saddle, Aft, In<br>: Various STC's<br>ISSUE P/O: _____<br><br>***MASK HOLES PRIOR TO<br>PRIME AND PAINT AS PER<br>DWG NOTE 8***<br><br>1-PRIME AS PER DWG AND<br>QSI005 4.2.1.3.3 PRIMER<br>BATCH: _____<br><br>2-PAINT AS PER DWG AND<br>QSI005 4.2.2.4 PAINT<br>BATCH: _____<br><br>C OF C IS REQUIRED  | Firmed | -       |          | 4 pcs          | 0 pcs             | 4 pcs   | \$25.00/pcs      | \$100.00       |
| Grand Total: |        |         |                                                                                                                                                                                                                                                                                                           |        |         |          |                |                   |         |                  | \$400.00       |

## Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 1/10/19 1:46 PM dart.tsimiklis.chrisoula